

AMENDMENTS TO THE CLAIMS

Claims 1-12 (cancelled).

13. (new) A control rod for boiling water reactor, comprising:

a tie rod having a cruciform cross section;

a handle attached to an axially upper part of the tie rod;

a lower part support member or a velocity limiter attached to an axially lower part of the tie rod; and

sheaths attached to tips of cruciform arms of the tie rod, each of the sheaths having a U-shaped cross section;

wherein

the tie rod is provided with steps for welding the sheaths at the tips of the cruciform arms; and

the tip of each of the sheaths is welded to the tie rod by irradiating a surface of the tie rod with an axial center position of a YAG laser beam or a CO₂ laser beam in position shifted from an end face position of the step of the tie rod toward an axis center of the tie rod.

14. (new) A control rod for boiling water reactor, comprising:

a tie rod having a cruciform cross section;

a handle attached to an axially upper part of the tie rod;

a lower part support member or a velocity limiter attached to an axially lower part of the tie rod; and

sheaths attached to a lower end of the handle;

wherein

the handle is provided with a step for welding the sheaths at the lower end thereof; and

an upper edge of each of the sheaths is welded to the handle by irradiating a surface of the handle with an axial center position of a YAG laser beam or a CO₂ laser beam in position shifted from an end face position of the step of the handle to a side opposite to the sheath.

15. (new) A control rod for boiling water reactor, comprising:

a tie rod having a cruciform cross section;

a handle attached to an axially upper part of the tie rod;

a lower part support member or a velocity limiter attached to an axially lower part of the tie rod; and

sheaths attached to an upper end of the lower part support member or the velocity limiter, each of sheaths having a U-shaped cross section;

wherein

the lower part support member or the velocity limiter is provided with a step for welding the sheaths at the upper end thereof; and

a lower edge of each of the sheaths is welded to the lower part support member or the velocity limiter by irradiating a surface of the lower part support member or the velocity limiter with an axial center position of a YAG laser beam or a CO₂ laser beam in position shifted from an end face position of the step of the lower part support member or the velocity limiter to a side opposite to the sheath.